

# Work Order ID 70126

Friday, May 27, 2011 10:55:05 AM



Ship Monday

Page 1

Item ID: D3340-17

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Skidtube Protector

Start Date: 5/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf Date: 11-05-27 Pooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3340	Rev B

100 0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

25 4/05/30

1311-5-07

(4)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1311-5-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

S 11/05/30



130



Brake NC

Brake NC

Form as per dwg  
NC BRAKE

0.00

Memo

0.00

SPB 11/05/30

4

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/05/30



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 5/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Powdercoat

Powder Coating

M115128

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

2:40

4X ~~1~~ M-1 11/05/30

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

H ~~1~~ 11-5-30.

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Memo

0.00

11/5/30 40 52

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3340-17

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Skidtube Protector

Start Date: 5/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31

MF

11-05-30

W/O: 69499

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.05.31	140	Acceptable to use ZOGA MAT'L					<i>[Signature]</i> 11.05.31 P. J. H.	

Part No: D4029-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date &amp; initial all entries



# Picklist Print

Friday, May 27, 2011 10:55:02 AM

Page 1

Work Order ID: 70126



Parent Item: D3340-17



Parent Item Name: Aft Skidtube Protector

Start Date: 5/27/2011



Required Date: 5/30/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC  
11.05.26 now made in house DD verf:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S19GA 		Purchased		No		100	sf	0.0000	0.32	1.347368			
1010/1025 SHEET .040											1311-5-27		

OK to use  
M1010S20GA

CP 11.05.31

110 368

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

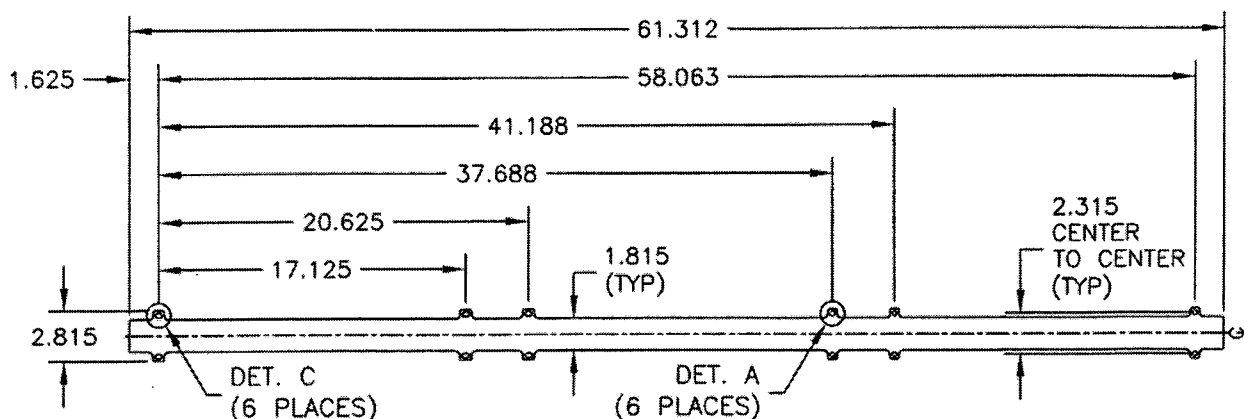
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**NOTE:** Date & initial all entries



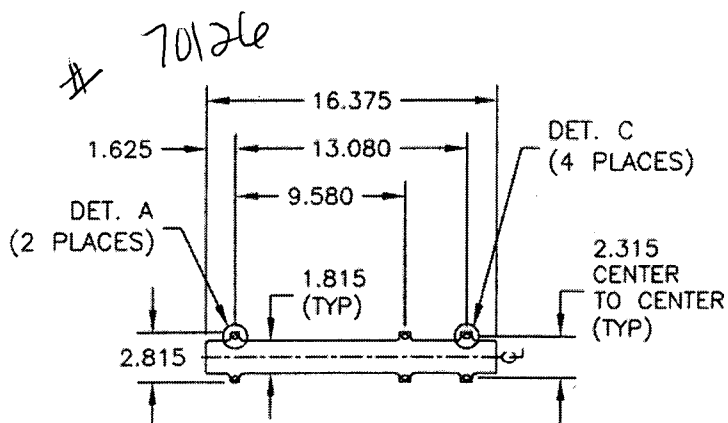
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 7 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



**D3340-15F FLAT PATTERN**

**RELEASED**  
05.11.28 *[Signature]*

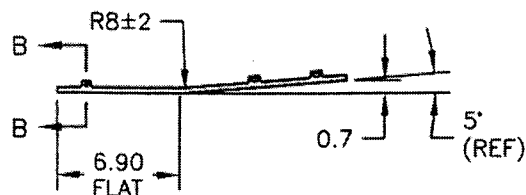
**D3340-15 CENTER SKIDTUBE PROTECTOR**



**D3340-17F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W  
SERIES COLD ROLLED STEEL 19 GAUGE  
(0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX  
(REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX



**D3340-17 AFT SKIDTUBE PROTECTOR**

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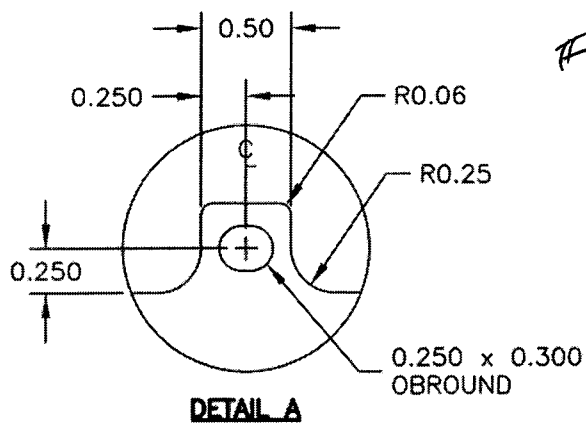
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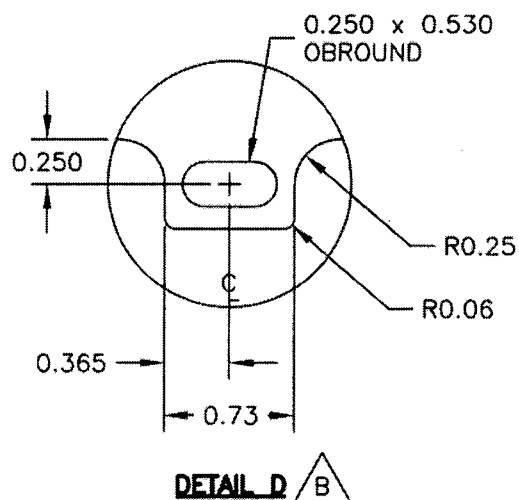
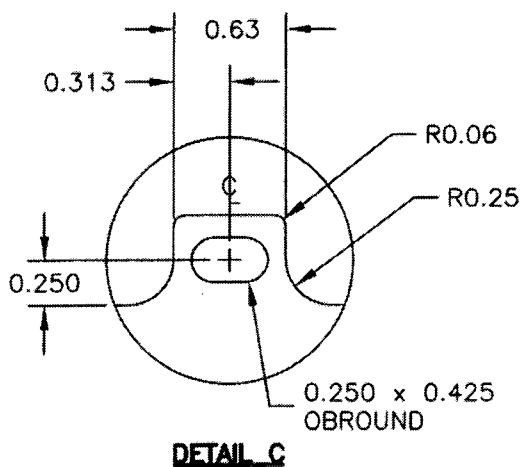
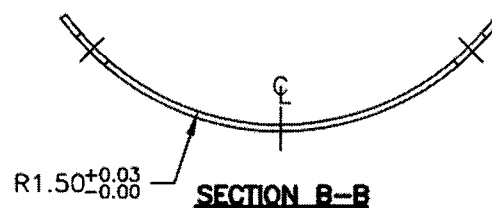
**NOTE:** Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



70126  
**RELEASED**  
05.11.28



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